Each

Monday, 2/11/2008 2:11:50 PM Date: Kim Johnston . User: **Process Sheet** : TUBE ASSEMBLY : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 37325 : 10923 **Estimate Number** (N'STENCTION) : D2003043 P.O. Number Part Number · UNDER BEVIEW : 2/11/2008 S.O. No. : **Drawing Number** This Issue : N/A : NC Prsht Rev. Project Number : // : SMALL /MED FAB : B First Issue **Drawing Revision** Type : 30374 Previous Run Material : 2/25/2008 **Due Date** Qty: 5 Um: Written By Checked & Approved By B 00.01.12 Re-format EC Comment **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: DOCUMENT CONTROL 1.0 Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D2003-043 2.0 M304TR0500W035 304 RD Tube .500 x .035W Comment: Qty.: 0.9406 f(s)/Unit Total: 4.7030 f(s) Material: 1/2"Æ x 0.035" wall AISI 304 SS tubing 3.0 SMALL & MEDIUM FAB RESOURCE Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Form tube as per template D2003-043 4.0 QC5 INSPECT WOR Comment: INSPECT WORK TO CURRENT STEP M26506 Firesleeve-crkl .375IDia

5.1188 f(s)

Sleeve

Total:

1.0238 f(s)/Unit Material: M2650-6 Heat sleeve

Comment: Qty.:

MS208198J

6.0

Dart Aerospace Ltd.

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Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>28/03/0</u> 0
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NOTE: Date & initial all entries

Monday, 2/11/2008 2:11:50 PM Date: User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: TUBE ASSEMBLY Job Number: 37325 Part Number: D2003043 Job Number: Seq. #: Description: Machine Or Operation: 7.0 AN8188J 2.0000 Each(s)/Unit Comment: Qtv.: Total: 10.0000 Each(s) Pick: Batch <u>M1060</u>74 **Qty Part Number** Description 2 AN818-8J 8.0 D2182 Heat Shrink Comment: Qty.: 1.8750 f(s) 0.3750 f(s)/Unit Total: Pick: Qty Part Number Description 1 D2182-045 Heat shrink SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Cut as per template D2003-043 (10.75" long) 2-Cut: 11.7" long as per Dwg D2003 3-Assemble as per Dwg D2003 10.0 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 11.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 12.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

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NOTE: Date & initial all entries





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CHEC	KEP .	APPROMED	DRAWING NO. REV. 8						
4	15	1 47	D2003 SHEET 1 OF 2						
DATE	1		TITLE SCALE						
 99.0	6.08		206 CABIN HEATER TUBE ASSEMBLIES NTS						
Α		90.04.09	NEW ISSUE						
R		99.06.09	UPDATE PER TEMPLATES: ADD P/N'S:						

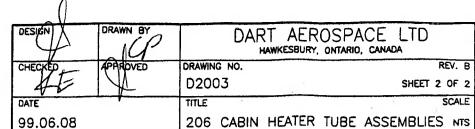
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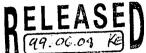
0.025 TUBING NOW 0.035 (TSR1049) OF BEL THIS UNDER REVIEW

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P/N	TEMPLATE	HEATSLEEVE LENGTH	CUT LENGTH OF TUBE ²	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	ENGINEERING UNCONTROLLED C SUBJECT TO AMENDA WITHOUT NOTICE WORK ORDER NO. 37325	
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33,31	32.38					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2		1 4 1			TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25					_1	1_	JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0				<u> </u>				HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0 9.75	0.60							HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205 D2003-207	T2003-205 T2003-207		9.60		-			2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-207	12003-20/	3.75	3./5					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
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Notes:

(1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.

(2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.

(3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.

(4) ENSURE SEAMLESS TUBING IS USED.

(5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.

(6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.

(7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.

(8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

5/16 × .20 GRUB

SCREW, INSTALL

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE VORK ORDER

MS 20819 - 6D SLEEVE ANBIB-60 NUT OHITTED FOR CLARITY

DETRIL OF - 077